

Ship 17/10 latest

Dart Aerospace Ltd.

Date: Tuesday, 14/10/2008 2:38:29 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT
Job Number : 42594	
Estimate Number : 10220	
P.O. Number :	Part Number : D219925
This Issue : 14/10/2008 S.O. No. :	Drawing Number : D2199 / D2638
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : E1/ A
Previous Run : 38454	Material :
Written By : <u>W</u>	Due Date : 17/10/2008 Qty: 2 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est:D 02.06.10 Rmv polish & add finish NG/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.7675 f(s)/Unit Total : 3.5349 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall
(M304TR0750W049)

Batch No: M109314

SB 08/10/16 (2)

2.0	BRAKE NC	NC BRAKE
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Comment: BRAKE NC

Punch per Dwg D2199 and Spec Control Dwg D2638

SB 08/12/16 (2)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SB 08/10/16 (2)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SB 08/10/16 (2)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 8:00

OVEN TEMPERATURE: 400

FINISH TIME: 8:30

8:00
400
8:30

M-1 08/10/17

(2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/10/2008 2:38:29 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 42594

Part Number: D219925

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FZ 08/10/17 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 264

JS 08/10/17 (FZ)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/17 JF

Job Completion



MA 08-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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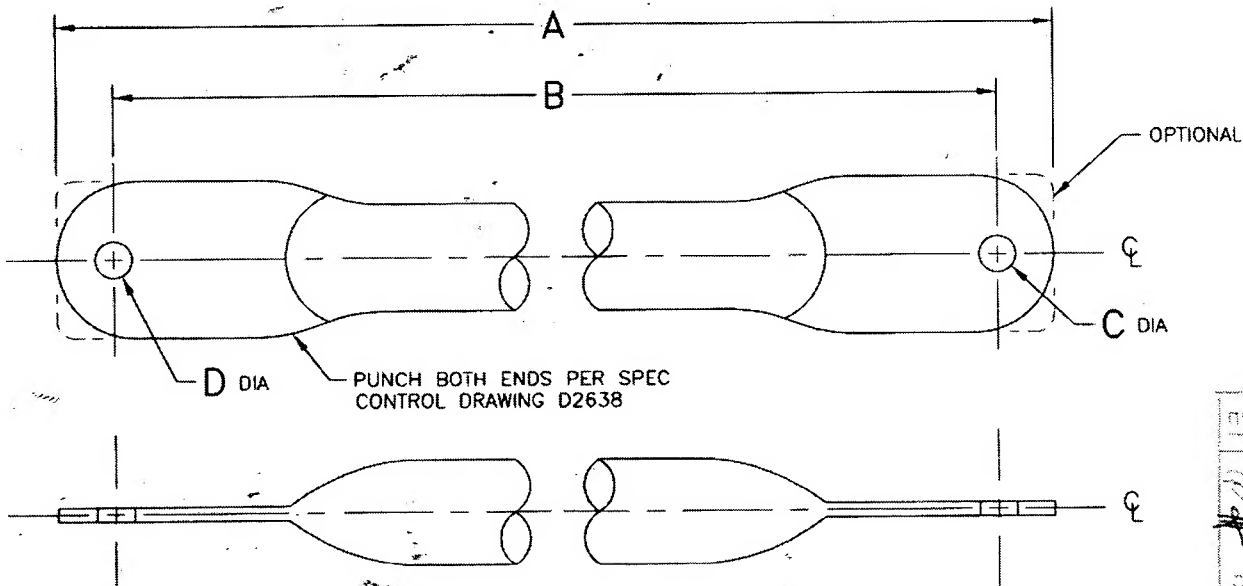
NOTE: Date & initial all entries

DART



RELEASED
98.05.05 4E

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
DATE		D2199	SHEET 1 OF 1
98.04.28		TITLE	SCALE
		STRUT DETAILS	NTS
A	1993	NEW ISSUE	
B		ADDED -11, -13, AND -15	
C		ADDED -17 AND -19	
D		ADDED -21	
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	



	A	B	C	D
D2199-1,	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

BBBCCOJJE
* 00.10.13
* 00.10.13

- NOTES:
1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
 2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
 3. FINISH: POWDER COAT WHITE (43.52) PER DART Q21.10.04 43/ET

WLD
42594